

Work Order ID 127054

127054

Page 1

Monday, January 12, 2015 11:35:12 AM

Item ID: D206-559-033 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw Wearplate
 Start Date: 12/4/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/5/2014 Req'd Qty: 1.00 ***1*** Customer: CAMET01
 Reference: RMA RA111924

Approvals: Process Plan: mf Date: 15-01-12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D206-559	REV L

100 0.00
100
 QC Memo 0.00
 Quality Control INSPECT RA 111924 D206-559-033 X 1 B113259
 KIT IS COMPLETE AND CAME IN @ CHG 002...OK TO SHIP PER ECN 14-544
 ID AND STOCK UNDER NEW BATCH NUMBER

110 Identify as per dwg & Stock Location: 86129 0.00
110
 Packaging Memo 0.00
 Packaging

15-01-12 DAS 9 9-89

1 JAN 20 2015 DAS 85 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Item ID: D206-559-033

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw Wearplate

Start Date: 12/4/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/5/2014 Req'd Qty: 1.00

1

Customer: CAMET01

Reference: RMA RA111924

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC21- Final Inspection - Work Order Release

0.00

120

QC

Memo

0.00

Quality Control

MLJ 15-01-21

H 15-1-20

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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, January 09, 2015 1:18:44 PM

Page 1

Work Order ID: 127054

127054

Parent Item: D206-559-033

D206-559-033

Parent Item Name: Bearpaw Wearplate

Start Date: 12/4/2014

Required Date: 12/5/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM IPP Rev B
10.10.04 per DSI9527 EC verified by:DD IPP REV:C 14.05.01
AS PER ECN14-544 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D206-559-033

Manufactured No

Each 0.0000

1

D206-559-033

Bearpaw Wearplate

113259 mf 15-01-09

DQA: _____ Date: _____



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Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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RA111924

Received @ Dart December 3rd, 2014
Inspected@ Dart December 3rd, 2014

Customer: AIR METHODS
Customer contact: BRIAN LOUIE
Shipped from: LEWISTON, IDAHO US

Instructions for D206-781-023L02 B121392 ?
D206-559-013 B115833 sm
D206-559-033 B113259 ✓

ⓐ chge (2) OK to ship

- Kits are all complete
- Return in stock with new labels

Time Estimate = 1HOURS

Departments Required: Stores

Pictures Attached = N/A

QTY INSPECTED = 1 D206-781-023L02 B121392
1 D206-559-013 B115833
1 D206-559-033 B113259

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Unapproved									

FAULT CATEGORY

Landing Gear	General	Other	Other
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date:	14.04.02	Job No.:	ENG5105APR	ADR Yes/No:	N	ADR Date:		ECN #:	14- 544
Product No.:	D350-578	Created By:	DB	Approved By:	UP				
Product Name:	Bearpaw Installation	Checked By:							

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	Y	NF	14/04/30
Production Manager / Coord.	Y	LL/MF	14.04.30
Purchasing Coord.	N	CL	
Production Engineering Coord.	Y	DD/JLM	
Production Engineering Coord.	N	DL	
Customer Order Processing	N	RM/CC	

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
DQA / QA Coord.	Y	PS	14/04/30
QC Coordinator	Y	ED	14/04/30
Customer Support	Y	SW/LM	14.04.30
Customer Technical Support	Y	MB/HS	14.04.30
Marketing Manager	Y	KO	14.05.05
Sales Support Manager	Y	NM	14.04.30

Reason for Change:
Customer complaint (PAR14-331) regarding installation issues

Documents Affected:
DSI 9689 REV A, D3859 REV B, MDL-D350-578 REV H, *D4379-REV C*

IF APPLICABLE: NCR: 14-3521 PAR: 14-331 CAR: _____
PAPERWORK UPDATE ☐ PARTS MUST COMPLY ☒ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	Y	SW	50115935 / Case 7746 (NCR14-3521)	14.05.07
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings/Item ID's Under Review (URF)	N			
5	Update Master Document List (MDL)	Y	DB		14.04.02
6	Update Document Record (DR)	N			
7	Update Product Compatability Matrix	N			
8	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move / Update Electronic Files / Design Journal	Y	KJ		14.04.30
11	Update Product Specification Files (Bluefiles)	Y	KJ		14.04.29
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		14.04.29
13	Update Product Development Summary (STC applications)	N			
14	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
15	Create/Update Parts / STC Database	Y	KJ	DSI KIT	14.04.29
16	Update / Verify Airworthiness Release Certificate Database	Y	KJ	#17	14.04.29
17	Create / Update Change Record Form / Item Card Database	Y	KJ	DSI KIT CHG 001, D350-578-031 CHG 002	14.04.29
18	Create / Update Packaging Process Plan (PPP)	Y	KJ		14.04.29
19	Red Decals required on Packaging Process Plan (PPP)?	N			
20	Update Controlled Supplier Documents (Opulse) Database	N			
21	Update Grey Project Binder / Electronic Project Folder	Y	KJ		14.04.29
22	Update D-Part / M-Drawing / DSI / DEO Master Binders	Y	KJ		14.04.29
23	Manufacturing Licensing Agreement Update	N			
24					

Description / Action:
Wearplate Assy changed to Hex-style wearplate cups. Scrap all existing stock.
ENTER NO CHARGE IN SYSTEM FOR HELIPRODUCTS —
D206-559-033 @ CHG 003 FOR KITS USING HEX-STYLE WEARPLATE CUPS. PREVIOUS PARTS AT CHG002 OR EARLIER ARE OK TO SHIP

ECN Verified & Complete: *MP* Date: *14/5/6*

DQA: _____ Date: _____



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